

Date: Tuesday, 8/21/2007 3:42:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INSIDE WASHER
Job Number	: 34175		
Estimate Number	: 11152		
P.O. Number	: <i>N/A</i>	Part Number	: D32331
This Issue	: 8/21/2007	Drawing Number	: D3233 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: B
Previous Run	: 28610	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 9/10/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>20</i> Um: Each
Comment	: Est. B 05.03.31 Added Powder Coat KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR2000W500	1020-1025 Round Tube
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Comment: Qty.: 0.0656 f(s)/Unit Total : 0.6563 f(s)
 1020-1025 Round Tube
 Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall
 (M1020TR2.000W.500)
 Identify for D3233-1
 Batch: *M102210*

DJP 07/09/15

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Turn as per Folio FA517 and Dwg D3233
 Deburr

DJP 07/09/15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/09/15

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 07/09/15

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FL 07/09/20

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:42:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSIDE WASHER

Job Number: 34175

Part Number: D32331

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

27/9/20 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

0211

27/9/20 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

27/09/21

Job Completion



U 27/9.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

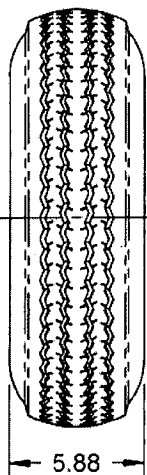
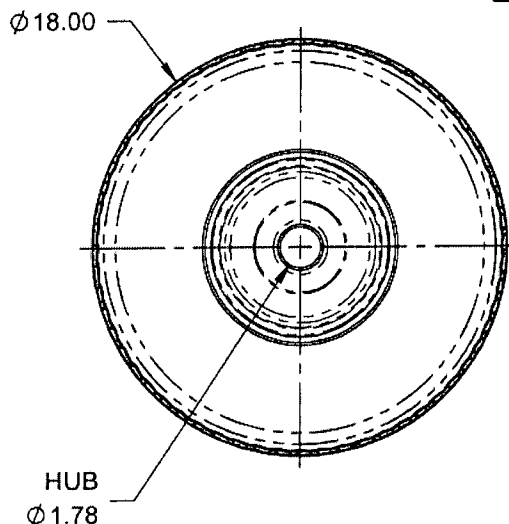
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

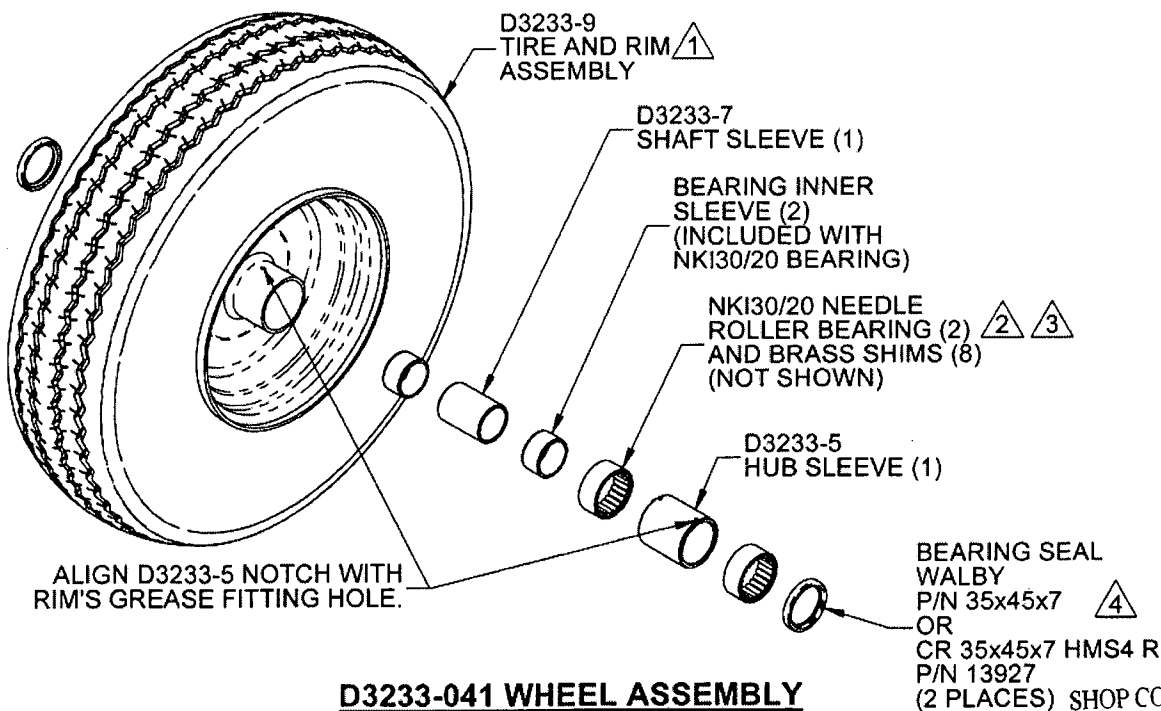
NOTE: Date & initial all entries

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**
[Signature]
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.**D3233-041 WHEEL ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

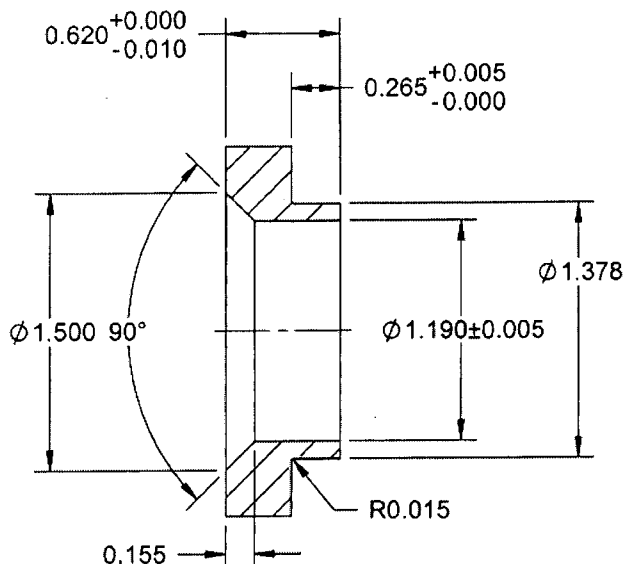
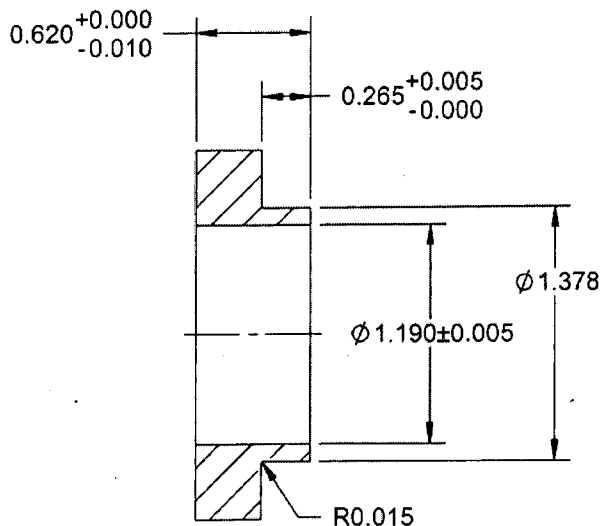
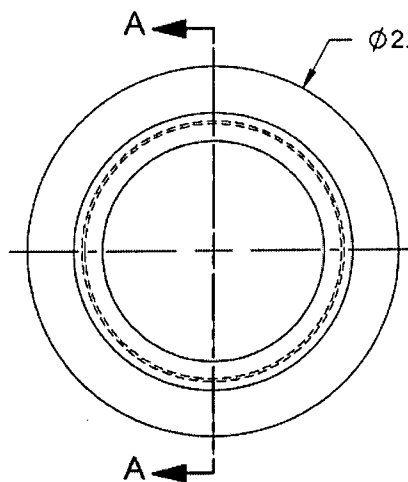
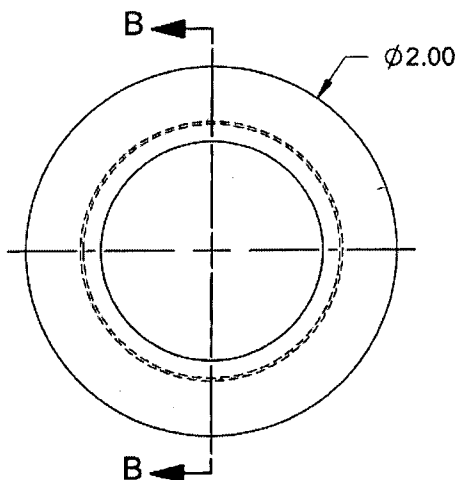
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, COLD DRAWN, SEAMLESS, MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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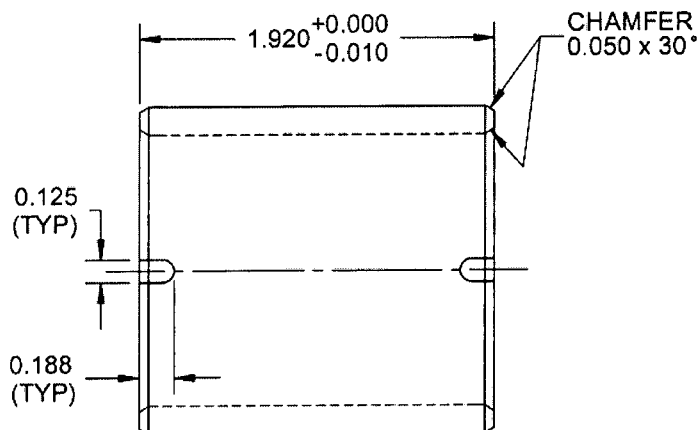
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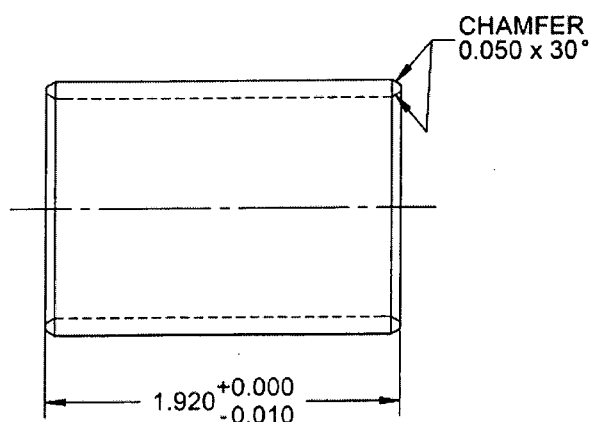
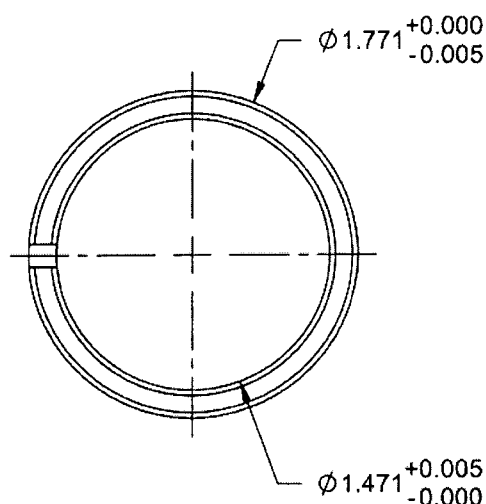


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

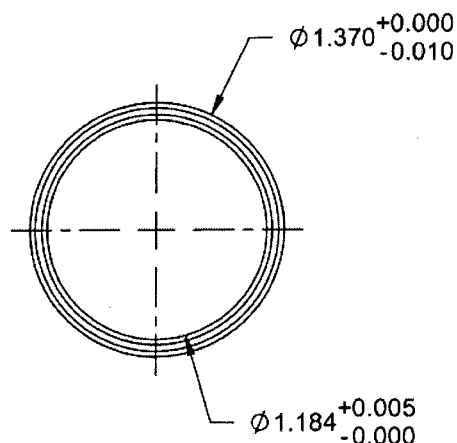
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[Signature]
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 ENGINEERING
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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